

Work Order ID 95433

95433

Page 1

January-09-13 1:44:49 PM

Item ID: D3212-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Floor Window

Stop

NS2

Start Date: 1/17/13 Start Qty: 10.00

10

Cust Item ID:

Required Date: 1/22/13 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: 13-01-10 Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr.								
100		0.00							
100	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut blanks per Dwg D3212	Dwg Rev: C	Prog Rev: C						
	2-Deburr if necessary								
110		0.00							
110	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per Folio FA349 and Dwg D3212								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120	Memo	0.00							
QC									
Quality Control									

OPE/B 2013-02-15

(10)

B13-1-28

OPE/B 2013-02-15

(10)

B13-1-28

OPE/B 2013-02-15

10

φ

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS									
Part No. _____	Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>									
NCR No. _____	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>	Quality <input type="checkbox"/>									
	Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Other <input type="checkbox"/>									
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector						
Doc/Data															
Equip/Tooling															
Operator															
Material															
Setup															
Other															
Process															
Supplier															
Training															
Unapproved															
FAULT CATEGORY															
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions						<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other				<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	

Work Order ID 95433

January-09-13 1:44:49 PM

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Page 2

Item ID: D3212-1

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Cust Item ID:

Required Date: 1/22/13 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

1/13/02/18

10 0

130

QC

Quality Control

Memo

0.00

140

140

Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

1-Deburr if necessary2-Install label as per Dwg D32123- polish abrasion
scratches if necessary.. 4-Wrap in plastic wrap after inspection

10X

E 13/02/26

150

150

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

SMB
13/02/26

10

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>				
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions							
				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Other							
				<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled							

Work Order ID 95433

95433

Page 3

January-09-13 1:44:49 PM

Item ID: D3212-1

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Floor Window

Stop

NS2

Start Date: 1/17/13 Start Qty: 10.00

10

Cust Item ID:

Required Date: 1/22/13 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____

Date: _____ Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____ SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

ST210

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

160

Packaging

Packaging

Identify as per dwg & Stock Location: ST210

0.00

10x

SP
13-2-26

170

170

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

13/2/26 JF

JMF

13-2-26

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

QA Closed: Date:

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS									
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermo-forming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other								
Part No. _____															
NCR No. _____															
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector						
Doc/Data															
Equip/Tooling															
Operator															
Material															
Setup															
Other															
Process															
Supplier															
Training															
Unapproved															
FAULT CATEGORY															
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio		<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled			
														<input type="checkbox"/> Other	

Picklist Print

January-09-13 1:44:48 PM

Page 1

Work Order ID: 95433

Parent Item: D3212-1

Parent Item Name: Floor Window

Start Date: 1/17/13

Required Date: 1/22/13

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev: A New Issue 05-11-09 JLM
IPP Rev: B Water jet/ ecn798 06-05-08 EC
IPP rev.C back on haas 07.04.09 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.125 1/8" Polycast II Sheet		Purchased	No			140	sf	518.7445	0.9745	10.257895			B13-1-28

Location	Loc Qty	Loc Code
MAT019	518.7445	
123704	79	
123895	343.7445	
123949	96	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

OA Closed: Date:

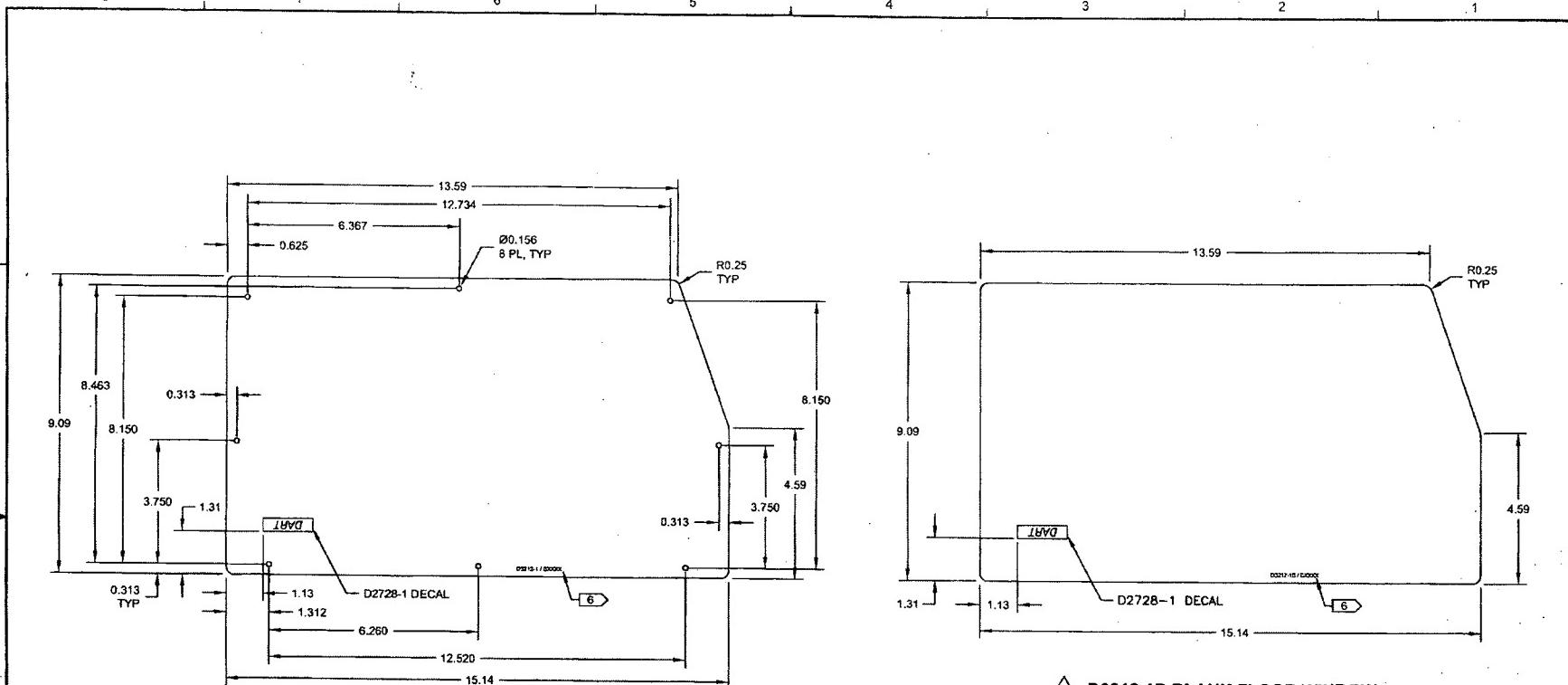
Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other			
Part No. _____ NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending	General			Bend	Grain	Ovalized	Pressure/Forced				
Centre Not Concentric to O/S				BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure				
Cracks				Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld				
Crushed/Crimped.				Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled				
Cuffs				Contamination	Maintenance	Part Moved					
Heat Treat				Countersink	Mislabeled	Positioned Wrong					
Inspection Strip in Tube				Cut Too Short	Misread	Power Loss/Surge					
Ripples in Bend				Drill Holes	Offset						
Torque Waves in Extrusion				Drawing	Out of Calibration						
Turning Sequence				Finish	Out of Sequence						
Wave/Twist in Tube				Folio	Outside Dimensions						

DART AEROSPACE LTD	Work Order:	95433
Description: Floor Window	Part Number:	D3212-1
Inspection Dwg: D3212 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Measured by: <u>J. B.</u>	Audited by: <u>✓</u>	Preliminary Approval:
Date: <u>2023-07-15</u>	Date: <u>13/02/18</u>	Date:

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF	
B	07.05.28	Dimensions updated per Dwg Rev. B	KJ/JLM	
C	12.02.01	Dwg Rev updated	KJ	



D3212-1 FLOOR WINDOW

NOTES:

- 1) MATERIAL: POLCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK REF. DART SPEC. M-ACRYLIC-S-125
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART PIN "D3212-X" AND B/N "BXXXXX" PER QSI 044 6.4 WITHIN 0.50 FROM EDGE
- 7) WEIGHT: 0.72 lbs
- 8) CHECK DIMENSIONS WITH TEMPLATE D3212-1T1

SHOP COPY
RETURNED
ENGINEERED
UNCONTROLLED
SUBJECT TO ANNUAL
WITHDRAWAL
WORK CENTER
NO. 05433 MCJ
13-01-10

B D3212-1B BLANK FLOOR WINDOW

RELEASED
2011-06-14
MJ

C	UPDATE TO CURRENT STD; ADD D3212-1B. REASON: PAR11-109.	MB	11.06.03
B	UPDATE MATERIAL PER NCR 029	SSH	06.04.13
A	NEW ISSUE	CP	03.09.03
REV.	DESCRIPTION		
DESIGN	<u>9P</u>	DART AEROSPACE LTD	HAWKESBURY, ONTARIO, CANADA
DRAWN	<u>1A</u>	DRAWING NO.	REV. C
CHECKED	<u>GP</u>	D3212	SHEET 1 OF 1
MFG. APPR.	<u>ED</u>	TITLE	SCALE
APPROVED	<u>MJ</u>	FLOOR WINDOW	NIS
DE APPR.	<u>MJ</u>	DATE	11.06.03
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